

Date: Monday, 14/04/2008 1:07:36 PM  
 User: Julie Lecocq

## Process Sheet

|                                    |   |                           |             |
|------------------------------------|---|---------------------------|-------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services   | <b>Drawing Name</b> :     | BEARING     |
| <b>Job Number</b> :                | 38591   |                           |             |
| <b>Estimate Number</b> :           | 10089   |                           |             |
| <b>P.O. Number</b> :               |   | <b>Part Number</b> :      | D312123     |
| <b>This Issue</b> :                | 14/04/2008  | <b>Drawing Number</b> :   | D3121 REV E |
| <b>Prsht Rev.</b> :                | NC  | <b>Project Number</b> :   | N/A         |
| <b>First Issue</b> :               | / /   | <b>Drawing Revision</b> : | E           |
| <b>Previous Run</b> :              | 37880   | <b>Material</b> :         |             |
| <b>Written By</b> :                |   | <b>Due Date</b> :         | 21/04/2008  |
| <b>Checked &amp; Approved By</b> : | JLP 08.4.14   | <b>Qty:</b>               | 50          |
| <b>Comment</b> :                   | Est. A: 04.02.19 New Issue KJ/DS<br>Est Rev:B ECN 1060 07-11-12 DD verified by:EC |                           |             |

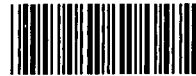
## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |    |            |
|-----|----|------------|
| 1.0 | PG | PURCHASING |
|-----|----|------------|



Comment: PURCHASING

Issue P/O: 6132

Bearing as per Dwg D3121

Possible Supplier: SKF P/N: 61900-2Z or KML P/N: 6900-2Z

Material release note is required

CL08104114 (50)

|     |        |         |
|-----|--------|---------|
| 2.0 | 6900ZZ | Bearing |
|-----|--------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)  
 Bearing

|     |             |                       |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

P.O. 8/4/21 (50)

|     |     |                   |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK

Inspect diimensions as per Dwg D3121 and attached certification Dwg Rev E

counts  
 CL08104121 (150)

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST66

AS 08/04/21 150

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 14/04/2008 1:07:36 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 38591

Part Number: D312123

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*W. S. Dunn*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

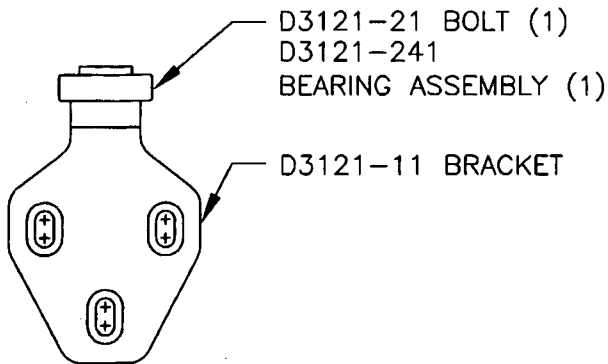
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

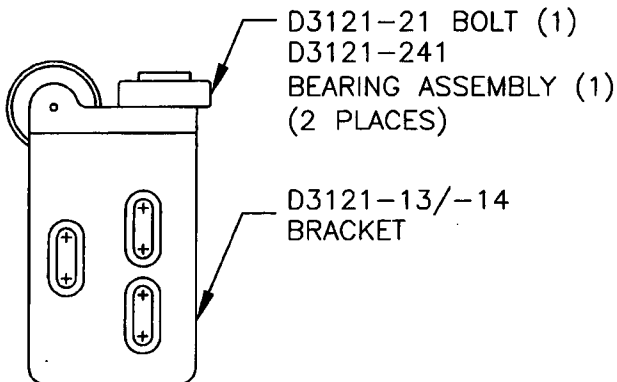
**NOTE:** Date & initial all entries

**DART**

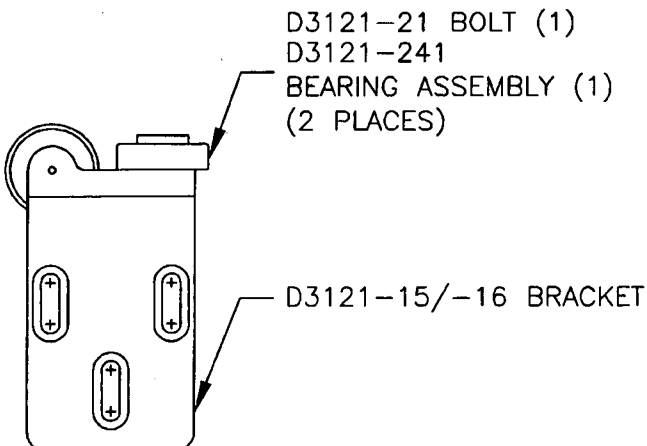
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| CHECKED<br>#     | APPROVED<br>#  | DRAWING NO.<br>D3121  | REV. E<br>SHEET 1 OF 10 |
| DATE<br>07.11.07 |                | TITLE<br>BRACKET ASSEMBLY   | SCALE<br>1:2            |
| A                | 02.04.15       | NEW ISSUE   |                         |
| B                | 03.01.16       | ADD RIDGES; ADD MAT'L PROP; FIX P/N<br>ADD -141/-143/-144/-145/-146 |                         |
| C                | 04.02.17       | ADD CLEARANCE; USE -241 BEARING                                     |                         |
| D                | 06.05.17       | D3121-25 CAP WAS 1.024, NOW 1.000                                   |                         |
| E                | 07.11.07       | ADD TOLERANCE TO 0.032 (DETAIL B)                                   |                         |

**RELEASED**  
07.11.07

**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-35/-36)

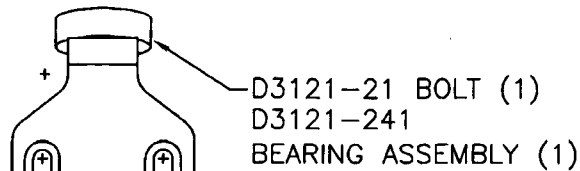
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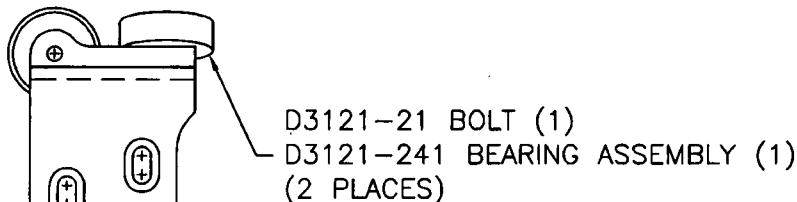
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| DATE<br>07.11.07 |                | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:2            |



**D3121-141 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23001-01)

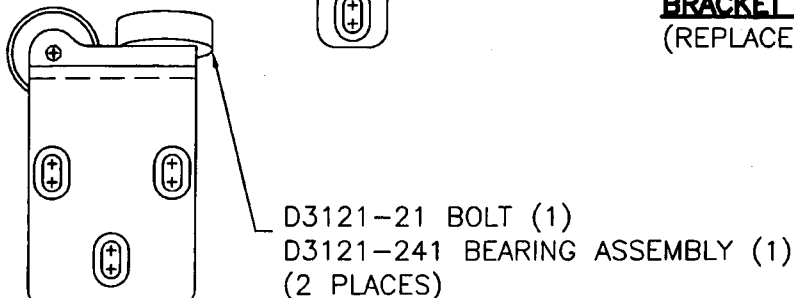
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07.11.07

D3121-111 BRACKET



**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-03/-04)

D3121-113/-114 BRACKET



**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-05/-06)

D3121-115/-116  
BRACKET

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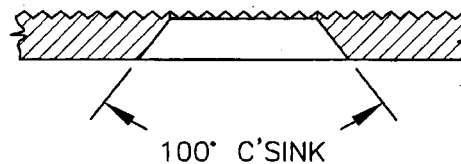
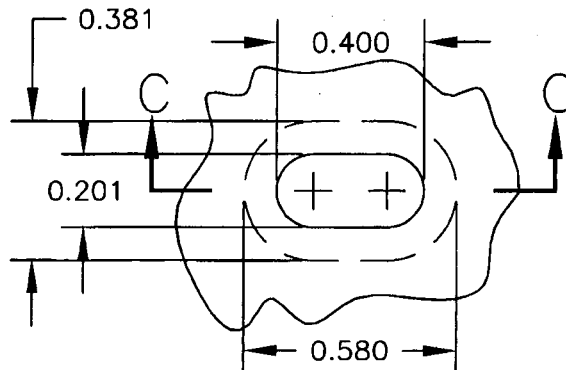
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| DATE<br>07.11.07 |                | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:1            |

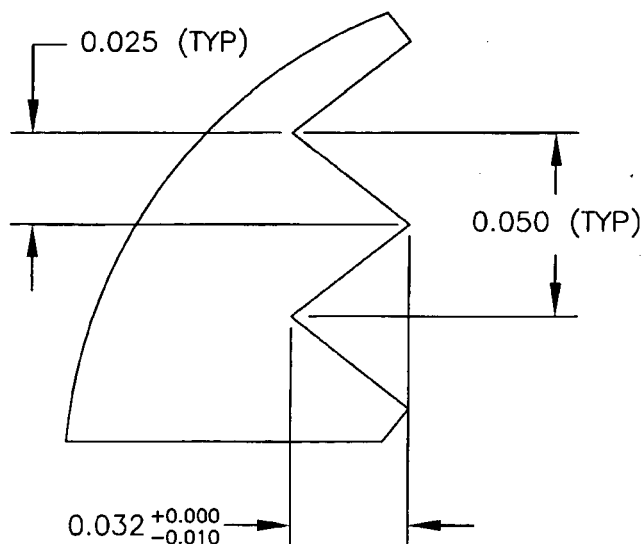
**DETAIL A:**  
**SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED



**SECTION**  
**C-C**

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07.11.07

**DETAIL B:**  
**RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20



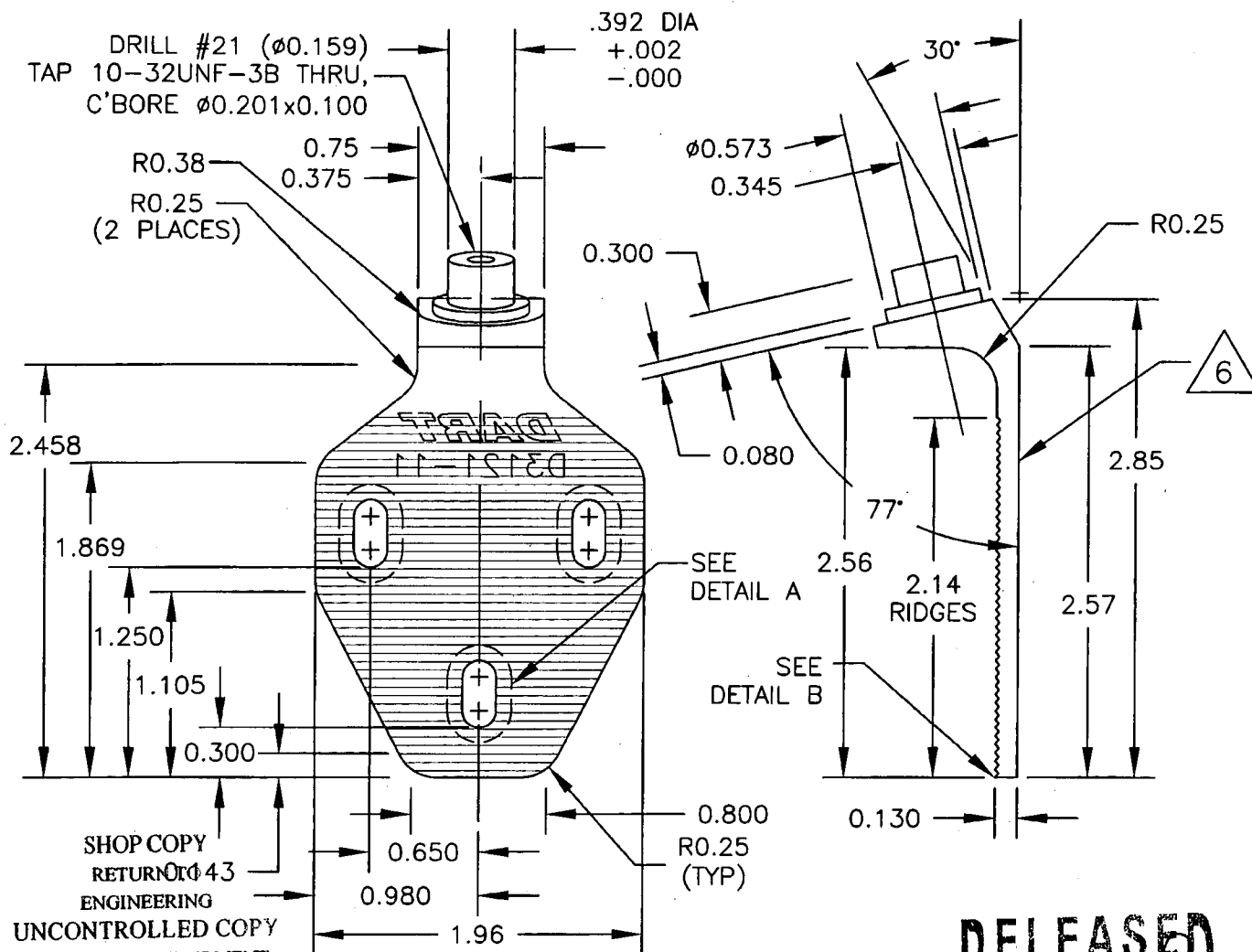
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| DATE<br>07.11.07 |                | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:1            |

**RELEASED**  
07.11.07 MB**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

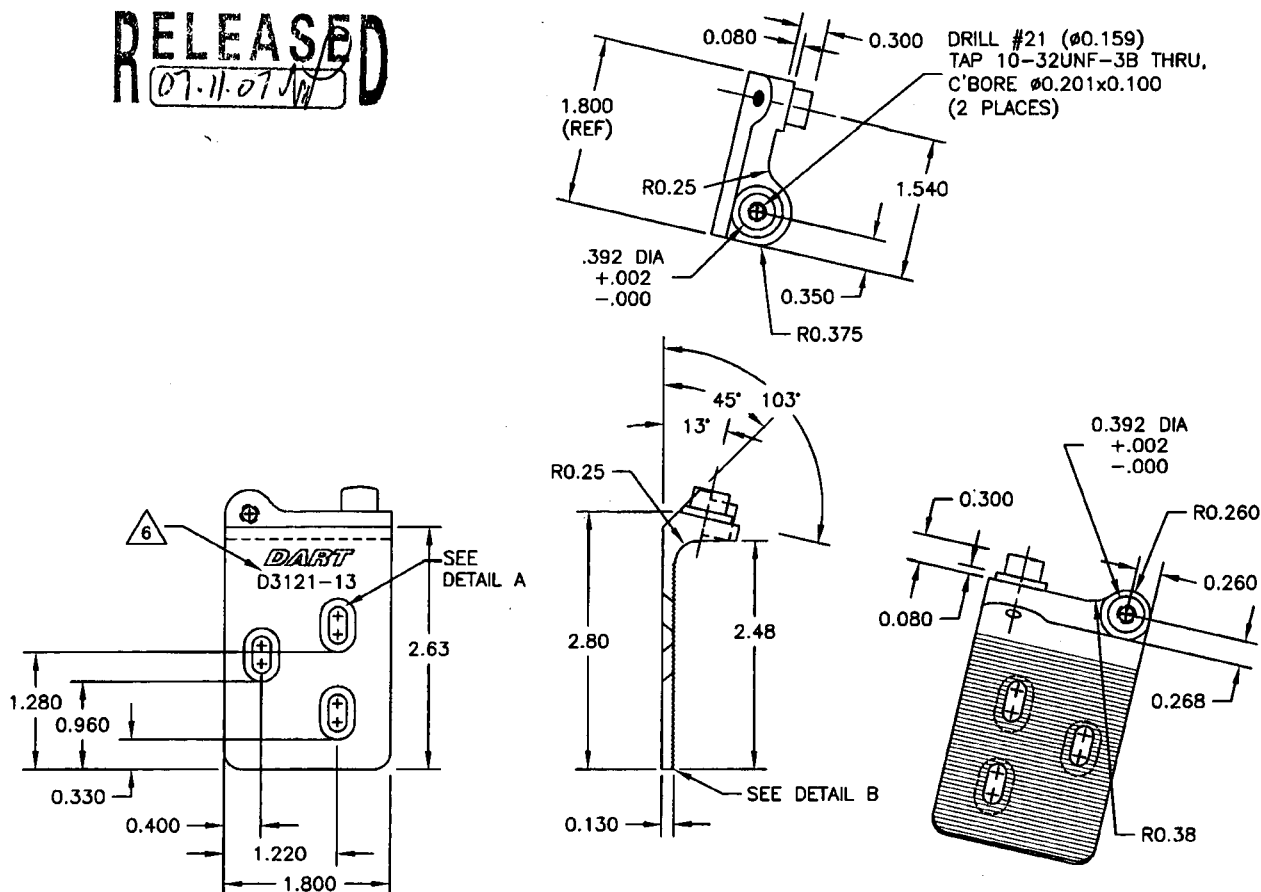
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| DATE<br>07.11.07 |                | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:2            |

**RELEASED**  
07.11.07

**D3121-13 BRACKET (SHOWN)**  
**D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

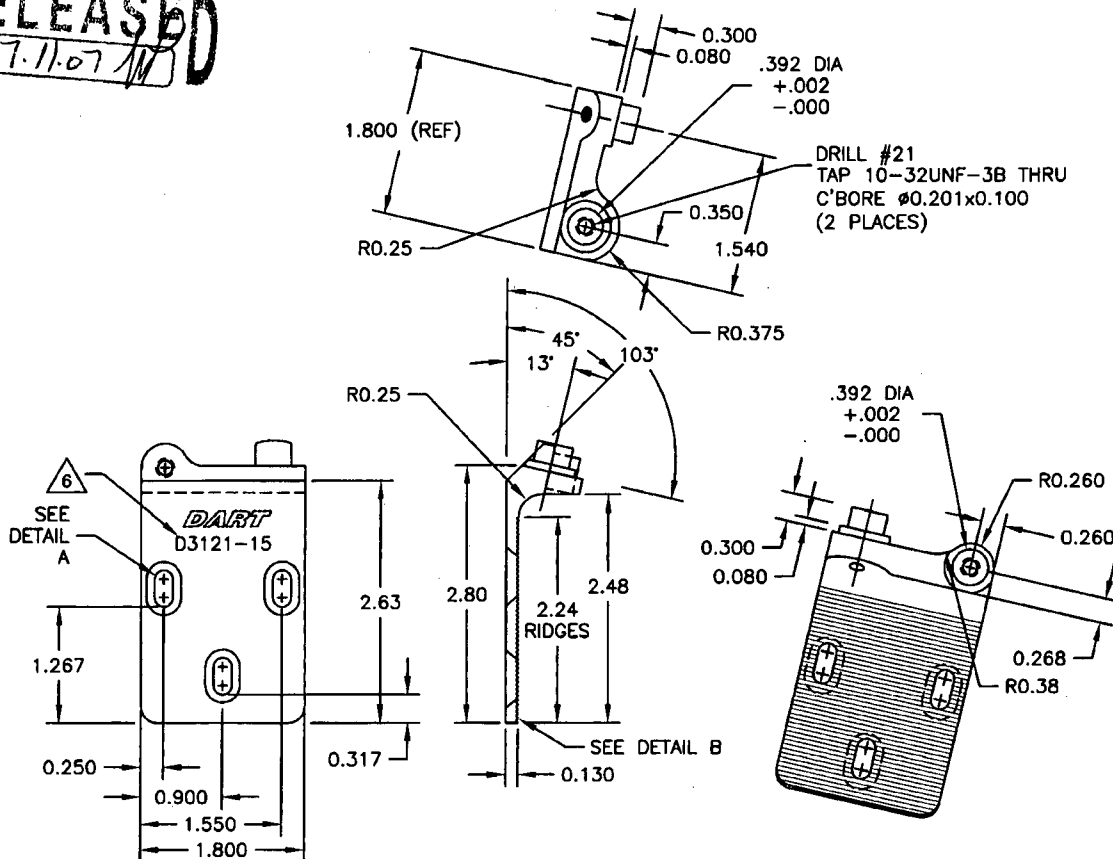
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| DATE<br>07.11.07 |                | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:2            |

**RELEASED**  
07.11.07

**D3121-15 BRACKET (SHOWN)**  
**D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

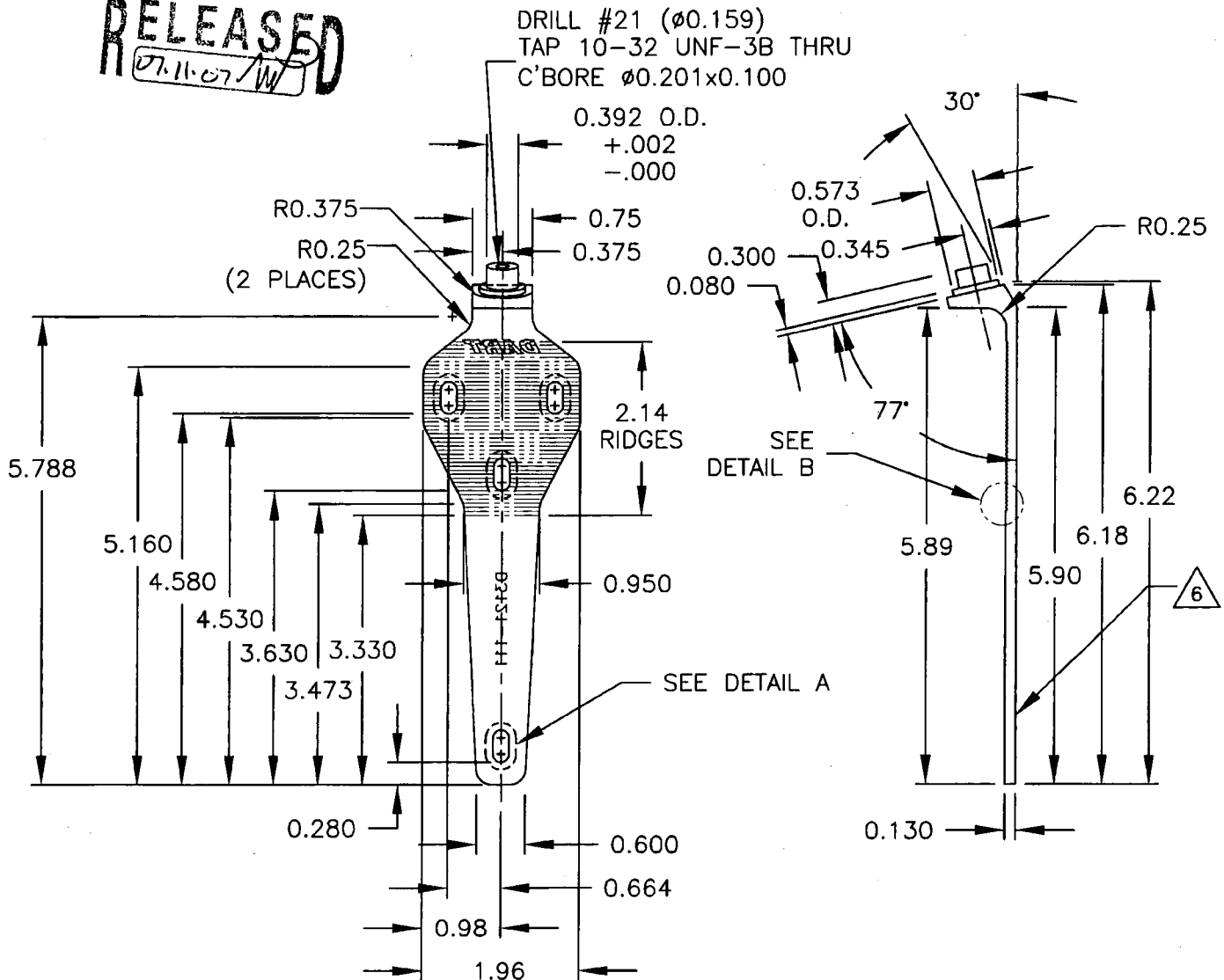
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| DATE<br>07.11.07 | TITLE<br>BRACKET ASSEMBLY |   | SCALE<br>1:2            |

**RELEASED**  
07.11.07/W**D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

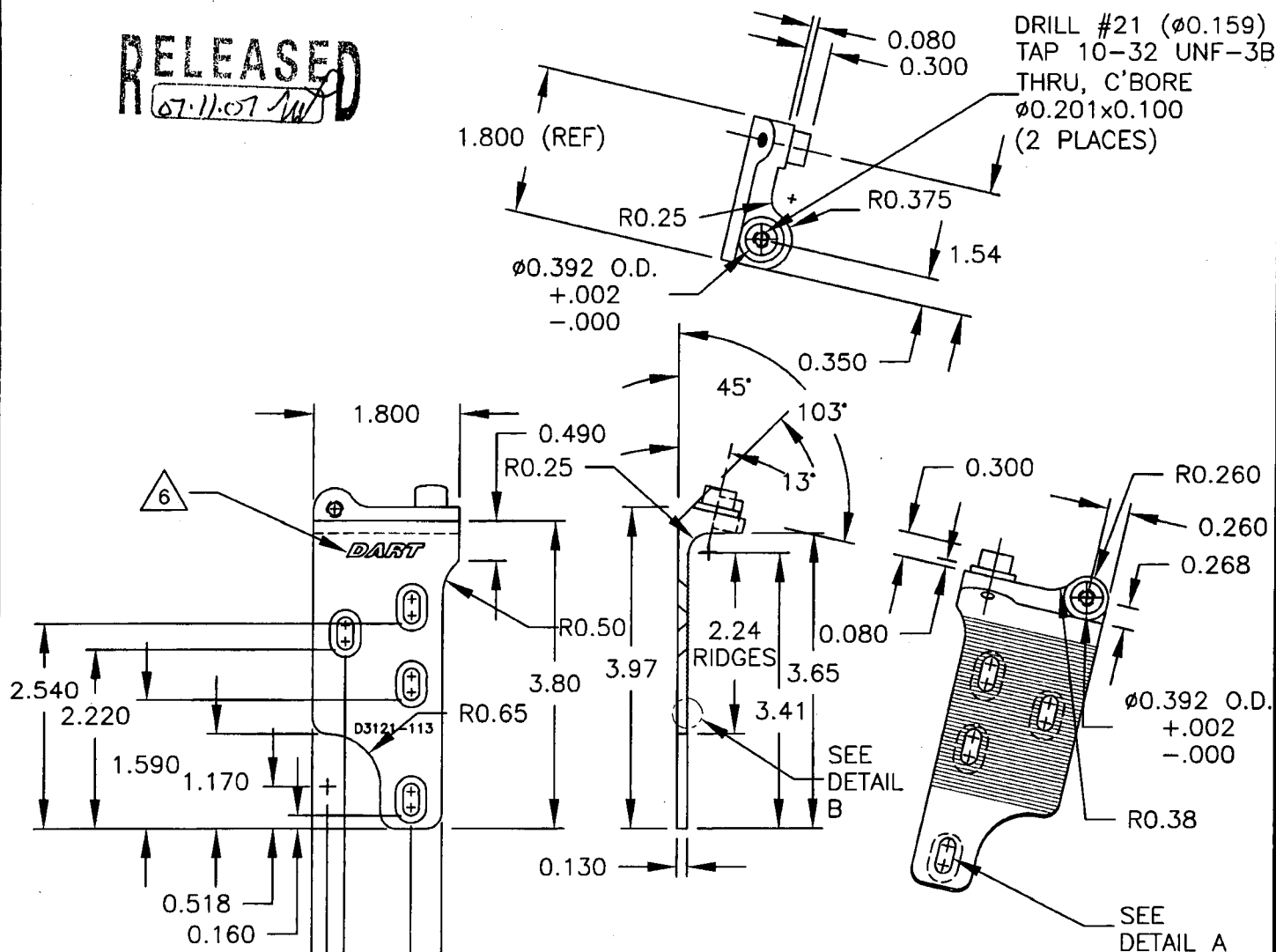
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| DATE<br>07.11.07 |                | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:2            |

**RELEASED**  
07.11.07

**D3121-113 BRACKET (SHOWN)**  
**D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13  
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

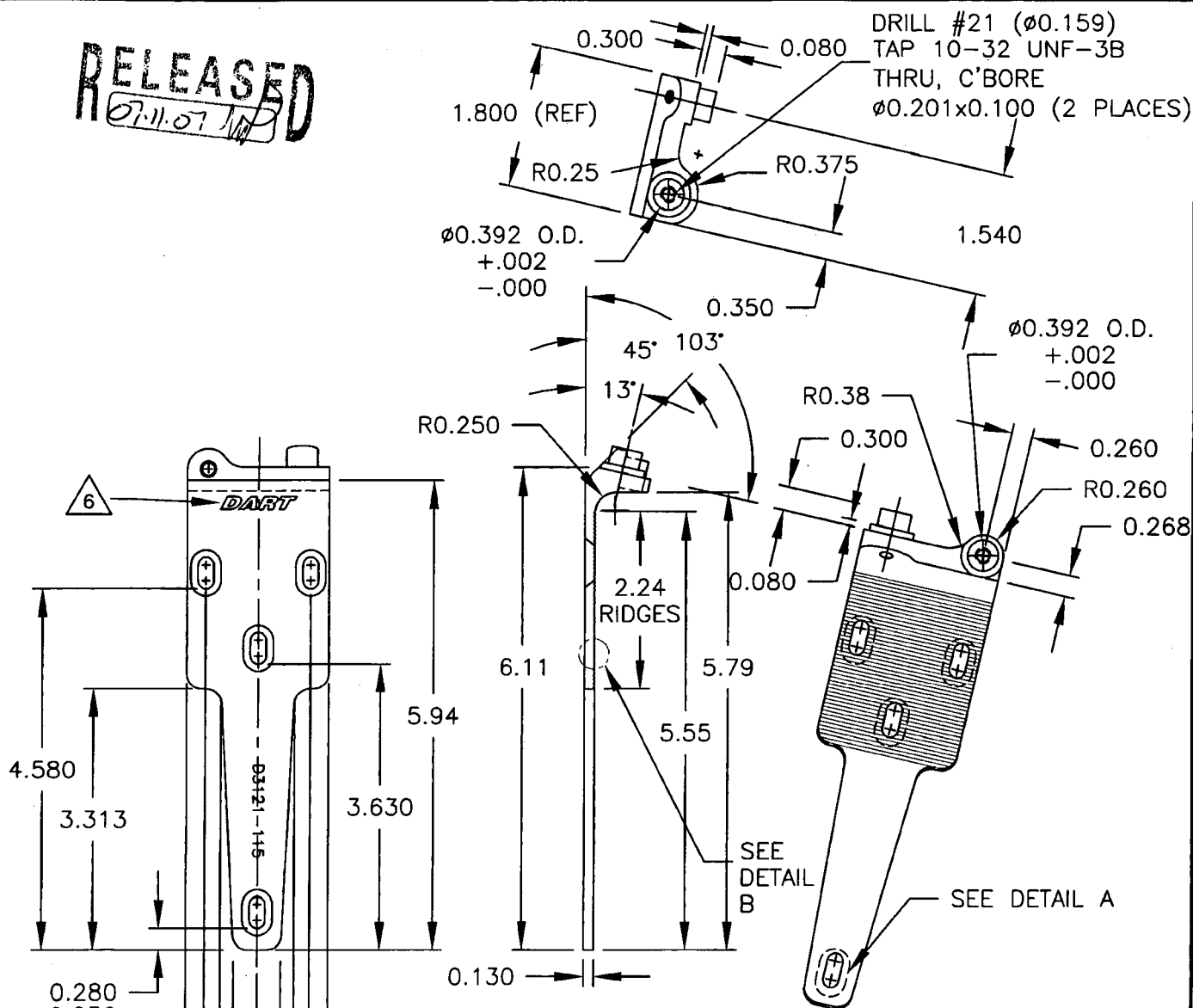
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| DATE<br>07.11.07 | TITLE<br>BRACKET ASSEMBLY |   | SCALE<br>1:2            |

**RELEASED**  
07.11.07**D3121-115 BRACKET (SHOWN)****D3121-116 BRACKET (OPPOSITE)**

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15  
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

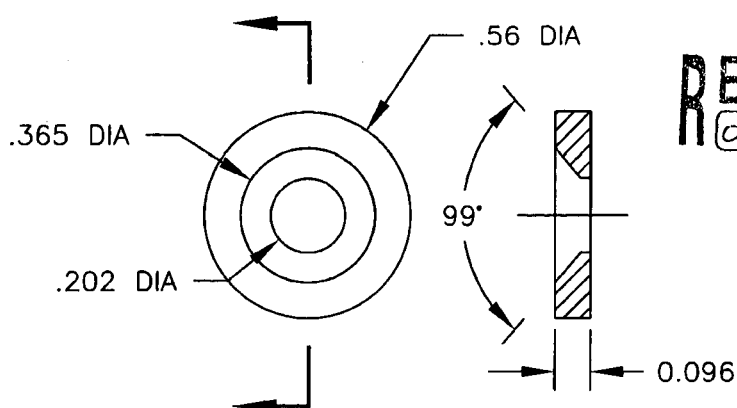
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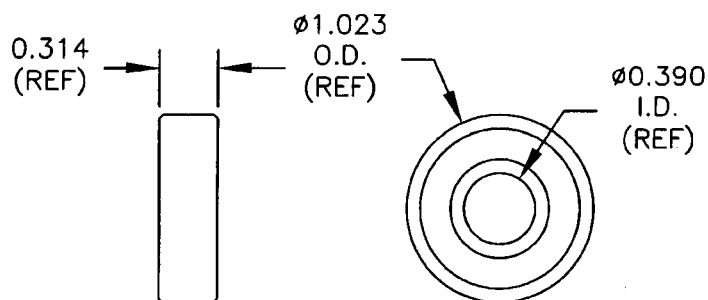
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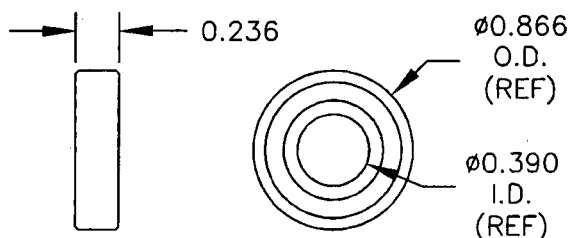
|                  |                           |   |                          |
|------------------|---------------------------|---|--------------------------|
| DESIGN<br>#      | DRAWN BY<br>LE            | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                          |
| CHECKED<br>#     | APPROVED<br>#             | DRAWING NO.<br>D3121                              | REV. E<br>SHEET 10 OF 10 |
| DATE<br>07.11.07 | TITLE<br>BRACKET ASSEMBLY |   | SCALE<br>1:1             |

**D3121-17 WASHER (SCALE 2:1)**

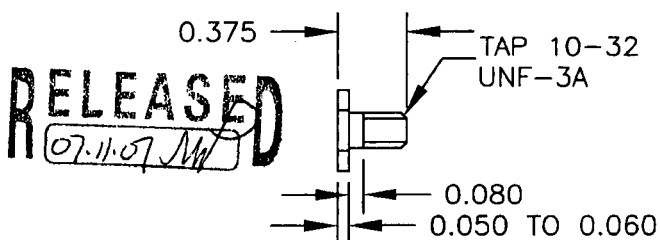
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

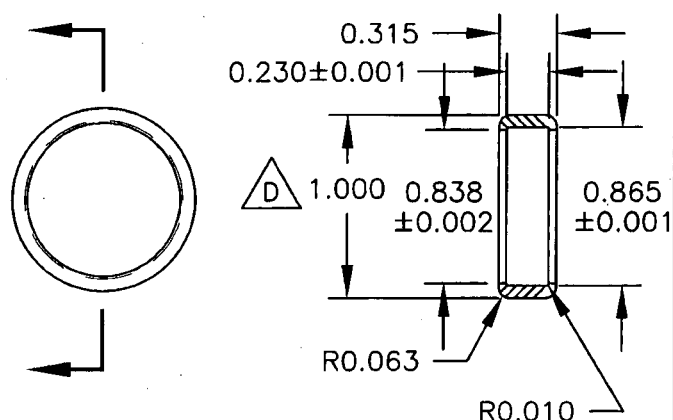
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

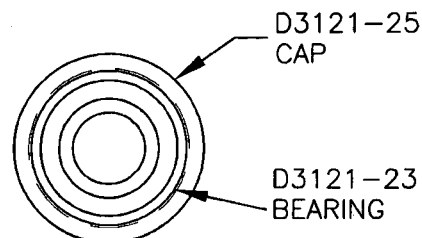
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

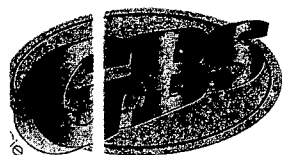
- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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• GENERAL BEARING SERVICE • Inc.

GST # R101579094

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1876 ARDEN STREET  
HAWKESBURY, ON

K6A-1K7

SALE TO: BY: DR  
SIP VAN

CUSTOMER ORDER #: 70.00006122

1ST LICENCE: 112-0771

| QTY     | DESCRIPTION      | SOLD | UNIT | PRICE | EXT    |
|---------|------------------|------|------|-------|--------|
| 893-6   | FAULTLESS CRATER | 4    |      | 19.21 | 76.84  |
| 8793-70 | FAULTLESS CRATER | 4    |      | 15.81 | 63.24  |
| 893-8   | FAULTLESS CRATER | 4    |      | 20.56 | 82.24  |
| 8793-1  | ALL BEARING      | 50   |      | 0.99  | 49.50  |
|         |                  |      |      |       | G.S.T. |

PICK UP SLIP NO: 534075-0

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*Robert Gaudreau*

1000000